User:

Wednesday, 6/6/2007 1:53:23 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 32788

Estimate Number

: 12716

P.O. Number

: 414

This Issue Prsht Rev.

First Issue

Previous Run

: 6/6/2007

: 31996

S.O. No. : 41/12

: SMALL /MED FAB

Project Number **Drawing Revision**

Drawing Number

Drawing Name

Part Number

Al4: Material : 6/19/2007

: GASKET

: D353635

: N/A

· D3536 REV A

Due Date

Qty:

20 Um:

Each

Written By

Checked & Approved By

Comment

: Est Rev:A

New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

FLOW WATER JET

MNEO60S063

NEOPRENE SHEET 0.063

Comment: Qty.:

0.6507 sf(s)/Unit Total:

NEOPRENE SHEET 0.063

13.0137 sf(s)

Batch:

M103104

0F/06/14

2.0

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: Prog Rev:___

2-Deburr if necessary

3.0



Comment: INSPEC PARTS AS THEY COME OFF MACHINE

SECOND CHECK

20

4.0

Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:___

Page 1

Form: rorocess

W/O:					<u>.</u>	V	VORK ORDER CH	ANGES			, - :		,
DATE	STEP		:		PROCI	EDURE CI	HANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
				1	<u> </u>								
			,	•									
:			5							,			
Part No:	·		P	AR #: _	<u> </u>	Fault Ca	tegory:	NC	R: Yes	NO DQA		_ Date: <u></u>	17/06/19
									QA: N/	C Closed	d:	_ Date:	
NCR:			i	:	WC	ORK OR	DER NON-CONFO	RMANC	E (NCR)			
DATE	STEP		Description Section			Initial	Corrective Action Action Descrip	Section B	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
07/06/19	2.0	Spart was no of a bla	Scrap bed of feeding ock in the Ave year	sause n Sand hose	mehini hedause	Chief Eng	Scrap, cleatroy, rep - Stop machine for	lace	5AD 57/06/14		16-18	OSION	10306.18
			1										
			, , , , , , , , , , , , , , , , , , ,										
:			1	,									

NOTE: Date & initial all entries

Date:

Wednesday, 6/6/2007 1:53:24 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32788

Part Number: D353635

Job Number:



Seq. #:

Machine Or Operation:

Description:

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd **WORK ORDER CHANGES** W/O: Approval **Approval** STEP PROCEDURE CHANGE DATE By Qtv Chief Eng / Prod Mgr Date QC Inspector Part No: _____ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC** Approval QC Inspector **Approval** DATE **STEP** Sign & Initial **Action Description** Section A Chief Eng Section C Date Chief Eng Chief Eng

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32788
Description: Gasket	Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.150	/		VM-T	
19.75	+/-0.030	19.75	~		M-T	
17.75	+/-0.030	17,75		i	M-T	
14.25	+/-0.030	14.25	/	·	M-T	
9.50	+/-0.030	9,50	/		m-T	
4.75	+/-0.030	4.75	_		M-1	
2.00	+/-0.030	2,00	/		M-T	
6.00	+/-0.030	6.00	/		M-T	
6.75	+/-0.030	6,75			M-T	
0.30	+/-0.030	0,308			Very	
0.30	+/-0.030	0.308	/		Ven	
1.89	+/-0.030	1,88			Vern	
Ø0.19	+0.005/-0.001	0.20	/		Vern	
0.063	+/-0.010	0.059	~		Vern	
`				į		

Measured by:	5M	Audited by:	Prototype Approval:	N/A
Date:	07/06/H	Date: 07/06/18	Date:	N/A
		- 11		

Rev	Date	Change	Revised by	Approyed
Α	07.03.14	New Issue	KJ/JLM	adl
			771	

84.02.12

ফ Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. **PURPOSE**

엻

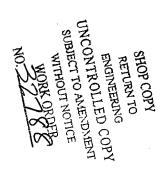
COPIED

抾

DOCUMENT

26.65 23.15 21.15 17.65 13.40 -9.15 - 0.90 5.65 1.89 DETAIL A 3.90 Ø0.19 14.00 (TYP 3 PLS)

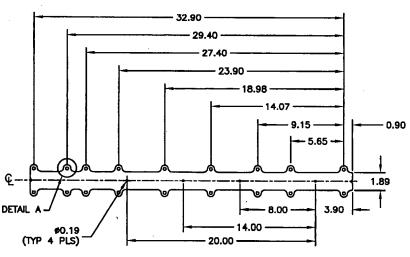
D3536-11 GASKET



1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-13 GASKET

			1
GASKET 1:10		06.10.25	$\overline{}$
TITLE SCALE		DATE)
D3536 SHEET 1 OF 6	#	M	
DRAWING NO. REV. A	APPROVED //)
PORT HADLOCK, WA	CB	CB	
DART AFROSPACE USA. INC.	DRAWN BY	DESIGN	_

06.10.25

NEW

ISSUE

CHECKED

APPROVED

 \mathcal{Z}

D3536 DRAWING NO.

SHEET

2 약 SCALE 1:10

O

B

DART

AEROSPACE PORT HADLOCK,

USA,

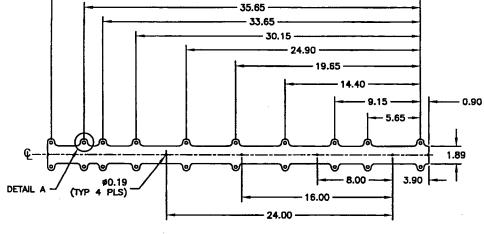
₹ C

DATE

06.10.25

GASKET





39.15

D3536-15 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT SHOP COPY WITHOUT NOTICE ENGINEERING RETURN TO

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

32.70 27.25 21.80 16.35 0.90 DETAIL A 1.89 2.00 - 6.00 8.00 #0.19 (TYP 4 PLS) 16.00 24.00

D3536-21 GASKET

N	С	ĺ	ı	Þ	3
4	~		8	4	•

롨

DOCUMENT

ᇬ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

유

COPIED

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) 2) FINISH: NONE

6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION

06.10.25

GASKET

CHECKED

 \mathcal{Z}

D3536 DRAWING NO.

SHEET

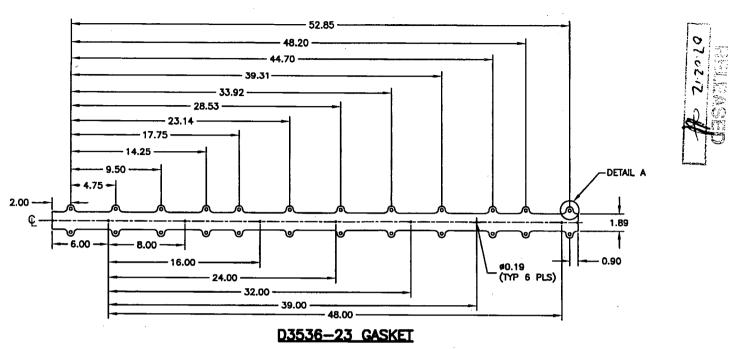
3 약 SCALE 1:10

B

DART

AEROSPACE

NO.



UNCONTROLLED COPY SUBJECT TO AMENDINENT SHOP COPY WITHOUT NOTICE ENGINEERING RETURN TO

붚S

DOCUMENT

ᇬ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

윢

COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

1.45 —— R0.06 (TYP)	21.80 ————————————————————————————————————
TOOLING NOTCH (TYP)	6.00 - 6.75 - 0.90 - 0.19 (TYP 3 PLS)

•	
<u> 03536–25</u>	GASKET



DATE 06.10.25 CHECKED B B D3536 DRAWING NO. GASKET DART **AEROSPACE** PORT HADLOCK, USA, 왕 NO. **4** 우

SCALE 1:10

19.00 2.00 ----6.00 -1.89 DETAIL A 6.00 **≠**0.19 (TYP 3 PLS) D3536-31 GASKET

07.02.12 2.00 ---6.00 -1.89 6.00 DETAIL A **#0.19** (TYP 3 PLS)

D3536-33 GASKET

23.25 19.75

D3536-35 GASKET

#0.19 (TYP 2 PLS)

DETAIL A

2.00

Ç 1.89

4.75

MOTES

봀

DOCUMENT

ឌ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT &
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED

OTHERWISE NOTED
) ALL DIMENSIONS ARE IN INCHES
) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
DERMANENT INK MARKER
SEE PAGE 6 FOR DETAILS AND SECTION
SEE ON TROLLED COPY
ON TROLLED COPY
ON TROLLED COPY
ON TROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

ZO.

PURPOSE

욹

COPIED

CHECKED

 \mathcal{Z}

D3536

B

る。

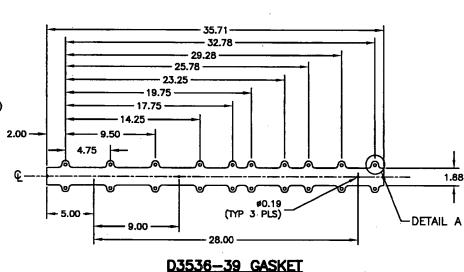
DATE

06.10.25

GASKET

20202

30.75 2.00 4.75 1.89 Q 6.00 16.00 DETAIL A 21.00 ●0.19 (TYP 4 PLS) D3536-37 GASKET



(0)12.

붚

DOCUMENT

ᄶ

Copyright © 2006 by DART AEROSPACE USA, IN PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART.

INC.

NOT TO BE USED FOR ANY I

RT AEROSPACE USA, INC.

PURPOSE

욹

COPIED

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT €
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

UNCONTROLLED COPY SUBJECT TO AMENDMENT 8 WITHOUT NOTICE RETURN TO ENGINEERING SHOP COPY

RC.

AEROSPACE (

DRAWING NO.

DART

USA,

5 약

::

27.98 25.08 18.50 2.00 -3.43 1.88 4.00 #0.19 (TYP 2 PLS) 3.90 **DETAIL**

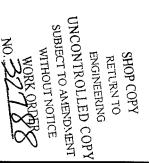
D3536-41 GASKET

MOTES

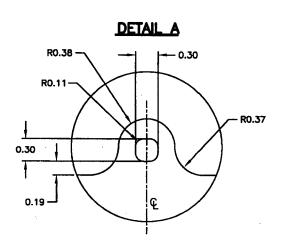
1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER







CB CB	DRAWN BY	DART AEROSPACE USA, INC.	NC.
CHECKED	APPROVED //	DRAWING NO.	REV. A
₹	#	D3536 SHEET	SHEET 6 OF 6
DATE			SCALE
06 10 25		CASKET	: